Quality Control

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W/O:	,		V \	ORK ORDER CHANGE	>				·	
DATE	STEP	PRO	CEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	NCR: `	es N	lo DQ	4 :	Date:	
	R	esolution:	Disposit	ion:	QA: N	C Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORMAN	NCE (I	ICR)				*
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Chief Eng	QC Inspector
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Page 2

July 23, 2009 10:06:42 AM

Item ID:

D2224

Revision ID: Ε

Rappel Anchor Item Name:

Start Date:

24/07/2009

Required Date: 31/07/2009

Start Qty: 30.00 Req'd Qty: 30.00



Accept



Setup Start

Stop



Reference:

Approvals:

Process Plan:

Date: Tooling:

QC: _____ Date: SPC (Y/N):

Run Hours

Set Up/

Date:

Date:

Draw

Rev.

Plan

Code

Cust Item ID:

Customer:

Draw

Number

Run

Start

Reject

Qty



Number Stamp

Insp.

Stop

Reject

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

0.00

0.00

cml 09/08/07

Qty

Accept

140

Outsource4

Outsource process - Anodize

Memo

Outsource process-Anodize per QSI017 4.1.10.1

0.00

0.00

☐Red Anodize as per Dwg D2224 MIL-A-8625

150

Packaging Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

CX 09/08/07 (30)

0.00

Dart Aeros	pace Lte	d
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W/O:				ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:		R: Yes I	No DQ	A:	Date: _	
	R	esolution:	Disposition	on:	_ QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORE	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			tion B		Verification		Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 50878

Ε

July 23, 2009 10:06:42 AM



Page 3

Item ID:

D2224

Setup Start



Revision ID:

Item Name: Rappel Anchor

Start Date: 24/07/2009

Start Qty: 30.00

Required Date: 31/07/2009

Req'd Qty: 30.00



Cust Item ID: Customer:

Reference:

Approvals:

Date:

0.00

Accept

Tooling: SPC (Y/N):

Date:

Date: ____

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

Quality Control

Operation **Description**

QC5- Inspect part completeness to step on W/O

Memo

QC: Date:

INSPECT ANODIZE

Set Up/ **Run Hours**

2) 509/00/cc

Draw Number Rev.

Plan Draw Code

Reject Accept Qty

Reject Insp. Number Stamp

170

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09 (08/21 A) MF 09-08-21

Dart Aerospa	ace	Ltd
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W/O:			WC	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCF	R: Yes N	lo DQ	4:	_ Date: _	
	R	esolution:	Dispositio	າ:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)			*,	
DATE	STEP	Description of NC	Initial		tion B	Sign &	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
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Picklist Print

July 23, 2009 10:06:42 AM

Work Order ID: 50878

Parent Item:

D2224RevE

Parent Item Name: Rappel Anchor

Comments:



Start Date: 24/07/2009

Required Date: 31/07/2009

Page 1

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M7075T73B2.500X03.2		Purchased	No			100	f	5.3300	6.9789			



7075-T73 Bar 2.50 x 3.25

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	5.33		
102694	5.33		
112331	12.00		7.5833
	<i>y</i>	A 09/08/0	2

Dart Aerospace	Ltd
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W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	<i>,</i> [Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•						·
Part No	:	PAR #:	Fault Cate	egory:	NCR: Y	es No	DQA	٨:	_ Date: _	
	R	esolution:	Disposition	on:	QA: N/0	C Clos	ed:		Date:	
NCR:			WORK ORD	ER NON-CONFO	RMANCE (N	ICR)				
DATE	STEP	Description of NC		Corrective Action	Section B		Verific		Approval	Approval
	OIL.	Section A	Initial Chief Eng	Action Descript Chief Eng		gn & late	Section	on C	Chief Eng	QC Inspector
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		V.								
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DART AEROSPACE LTD	Work Order:	50878.
Description: Rappel Anchor	Part Number:	D2224
Inspection Dwg: D2224 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST									
			X First Ar	ticle [Prot	otype			
	rawing nension	Tolerance	Actual Dimension	Accept	Reject	Method Inspect		omments	
	0.188	+/-0.010	132	1					
0.0	50 x 45°	+/-0.010 x 0.5°	.050						
	0.250	+/-0.010	,251	/					
F	R0.500	+/-0.010	.500	/					
	3.000	+/-0.010	3.002	/	-	-			
Q	0.507	+0.008/-0.001	.508	/					
. (0.750	+/-0.010	.750	1					
	2.313	+/-0.010	2.314	/					
	1.687	+/-0.010	1.689	/					
	2.438	+/-0.010	2.439	1					
	1.125	+/-0.010	1.126						
2	0.313	+0.006/-0.001	.315	/					
	V								
					<u> </u>				
	·····								
Meas	ured by:	A.B.	Audited by	: Sy		Prototy	pe Approval:	N/A	
	Date:	96 = 64 90	OG Date	: 02/0	867		Date:	N/A	
Rev	Date	Change					Revised by	Approved	
A	08.04.11	New Issue					KJ/DD CX	1 1/2	

Rev	Date	Change	Revised by,	Approved
Α	08.04.11	New Issue	KJ/DD 🚓	<i>X</i>
			• 0	

Dart Ae	rospace	e Ltd							•		
W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	'Approval QC Inspector			
						<u> </u>		· · · · · · · · · · · · · · · · · · ·			
			. •								
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	s No DG	A:	Date:	<u> </u>		
	R	esolution:	Disposit	ion:	QA: N/C Closed:			Date: _			
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NC	R)					
DATE	STEP	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		tion C	Chief Eng	QC Inspector		
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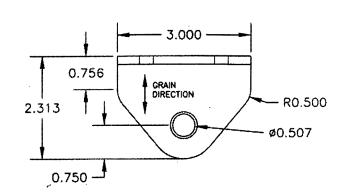
NCR:		V	VORK ORDI	ER NON-CONFORMANC	E (NCR)			•
	Ī	Description of NC		Corrective Action Section B	Verification	Ammuoval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
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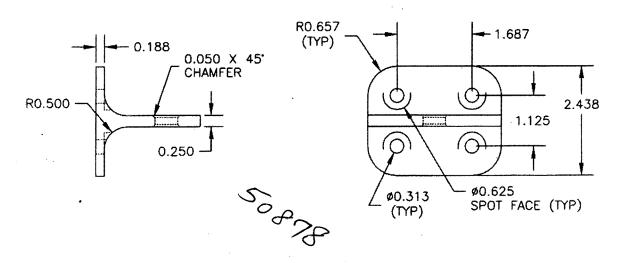




DESIG	M	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	•
CHEC	(EQ	APPROVED	DRAWING NO.	REV. E
	KE	#	D2224 SHEET	1 OF 1
DATE	/		TITLE	SGALE
99.0)4.29		RAPPEL ANCHOR	1:2
Α		94.03.10	NEW ISSUE	
В		95.04.11	D2227 WAS D2216	
C		96.06.17	ADDED D2224-60	
D		97.04.25	CHANGE TO T-SHAPE	
Ε		99.04.29	REVISE MATERIAL SPECIFICATIONS	







MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)

FINISH : ANODIZE RED PER MIL-A-8625

BREAK ALL UNMARKED EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

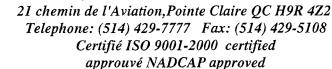
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W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No: PAR #:		PAR #:	Fault Cate	Fault Category: NCR: Yes No			o DQA: Date:			
Resolution:			Disposition: QA: N/C Closed: Date:							
NÇR:			WORK ORD	ER NON-CONFORMA	NCE	(NCR)				
		STEP Description of NC Section A			on B		Verific	ation	Approval	
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	,	Sign & Date		Chief Eng		
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				HP.						
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K6A 1K7

ANODISATION et PEINTURE TNM INC.

C. OF C



76659 8/14/2009



CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD.

1270 ABERDEEN STREET HAWKESBURY

ONTARIO

NO. DE COMMANDE: PURCHASE ORDER/

513966







ITEM	COMMANDE ORDERED	EXP SHIP		MBER & DESCRIPTION	PART PROCESS & TREATMENT
1	16	16	D2224	B50813	- Service to the contract of t
					RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	6	6	D2224	B50515	-
	/	<u></u>	\		RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	30	30	D2224	B50878	•
	(/		RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

5 38 / 26

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées. Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient

Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed,

Directeur de la Qualité 💆 K. Manager Part accopase 1270 alierdeen St. Hankoving ont. KGA-1K7

Nº DE COMMANDE - ORDER NO.	DÉP DEPT.	DATE	09/08/07	
VENDU À - SOLD TO	EXPÉDIÉ À - SHIP T	in methor	•	1 P D
ADRESSE - ADDRESS	ADBESSE - ADDREI	to - Classic	1 21 amater	422
DATE D'EXPÉDITION - SHIPPING DATE VIA	CONDITIONS - TERMS		AXE - TAX RÈG. NO. VENDEUR - S	9-777
		*		
16 1	D2224 B508/3			
(e D	2224 B 50515	5		
	2224 B 50875 Red anadize a		502/4/16	
	B/11/10/11B cla	20 Z		
	Persolutera acet E	763438	2	
		thank	Chart.	
	CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY			
			TPS/GST	
		1100010	TVP/PST	
513966 SIGNATURE	M° LICLIC. NC	0.	TOTAL	

Blueline DCB156

FORMULAIRE DE VENTE - SALES ORDER

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